

Work Order ID 158216***158216***

Tuesday, March 21, 2017 1:12:18 PM

Item ID: D2565-109 **Accept** ***N900040100*** **Setup** **Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Strut
Start Date: 3/23/2017 **Start Qty:** 3.00 ***3*** **Cust Item ID:**
Required Date: 3/29/2017 **Req'd Qty:** 3.00 ***3*** **Customer:**
Reference: SCHEDULED

Approvals: **Process Plan:** ^{DAS} **21** **Date:** MAR 21 2017 **Tooling:** **Date:** **Run** **Start** ***NR1***
QC: ^{9-89 **Date:** **SPC (Y/N):** **Date:** **Stop** ***NR2***}

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2565	Rev E ✓								
100	Punch ends and deburr as per dwg	0.09							
100	NC BRAKE					3	FF		MAR 28 2017
Brake NC	Memo	0.75							
Brake NC	Punch as per Dwg D2565 using DT 8313								
110		0.00							
110	Small Fab					3	FF		MAR 28 2017
Small Fab	Memo	0.31							
Small Fab	Deburr								
120	QC5- Inspect part completeness to step on W/O	0.00							
120						3			
QC	Memo	0.06							
Quality Control									

DAS
 38
 9-89
 MAR 29 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per OSI005 4.3-Steel <i>M136657</i> Memo START TIME: <i>9:15</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>9:45</i>	0.00 0.17				<i>3</i>	<i>1703-31</i>	<i>33</i>	<i>33</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.03				<i>3</i>			DAS 38 9-89 MAR 31 2017
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST354</i> Memo	0.00 0.03			DAS 6 9-89	<i>3</i>			DAS 41 9-89 MAR 31 2017

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.30							
Quality Control									

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Picklist Print

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Parent Item: D2565-109

D2565-109

Parent Item Name: Strut

Start Date: 3/23/2017

Required Date: 3/29/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP: F02.04.16Added dwg Rev.C1NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased				100	f	198.6040	1.0258	3.239368			

M304TR0 750W 049

304 RD Tube .750 x .049W

**

FF

MAR 28 2017

Location

Loc Qty

Loc Code

GA002

198.6039972

M135709

0.0000037

M136667

2.076315

M136760

20.2852605

M136846

36.242418

M136943

60

M137091

80

3.239368

